

Date: Tuesday, 02/12/2008 11:16:58 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
 Job Number : 43885
 Estimate Number : 10318
 P.O. Number :
 This Issue : 02/12/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : PURCHASED PARTS
 Previous Run : 34614
 Written By :
 Checked & Approved By : JLD 08.12.02
 Comment : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF

Part Number : D2659
 Drawing Number : D2659 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 05/12/2008 Qty: 14 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 43885A LUG



2 of these were
 SS. taken out
 of system

Comment: Sub-Component LUG

1 x D2657 Batch B34076A

EL 8-12-3

(X14) replace
 HSD

2.0 43885B LUG BRACKET



Comment: Sub-Component LUG BRACKET

1 x D2658 Batch 3X19607 11x B34076B

EL 8-12-3

(X14)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using Location Jig DT8208
 A/R Steel Rod M108350

EL 8-12-3

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-12-04 BE 08-12-04

(X12)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/08 (X12)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15

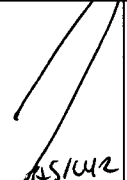
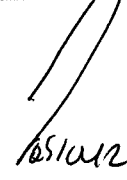
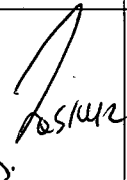

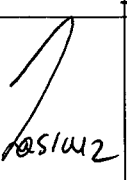
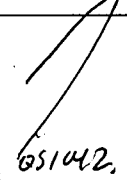
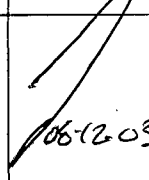
M-L

08/12/09

(12X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2659 PAR #: N/A Fault Category: Prod / FAB. Large NCR: Yes No DQA: FD Date: 08/12/12
 Resolution: Scrap Disposition: SCRAP QA: N/C Closed: D Date: 08/12/12

NCR: 43885		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/12/03	# 30	After welding welder notices that the D2657 lug ^{had} not changed colour. HE then Realized that the D2657 was stainless steel not mild steel.		SCRAP D3414-3 S.S lug Qty 2 also SCRAP D2658 steel lug Bracket Qty 2 no replace.	EL 8-12-3	S 8/12/03		S 08/12/03
		R.C. 2 was wrong D3414-3 were mixed with D2657. Didn't notice till after welding. Lack of attention on the employee who placed the S.S lug into the steel box.		- employees to check mat. to before welding with magnetic to ensure no mix ups. - S.S the work area, and ensure parts are correctly identified & stocked.				S 08/12/03
		Not the employee affected on this W.O. 2						 06-12-03

NOTE: Date & initial all entries

Date: Tuesday, 02/12/2008 11:16:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 43885

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description:

OVEN TEMPERATURE:

FINISH TIME:

400 OF
11-45

M-L 08/12/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



98



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 465

SS 08/12/11 (12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-12-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

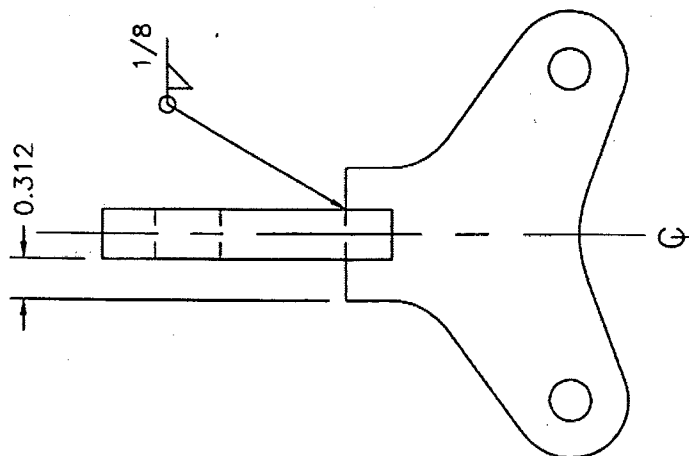
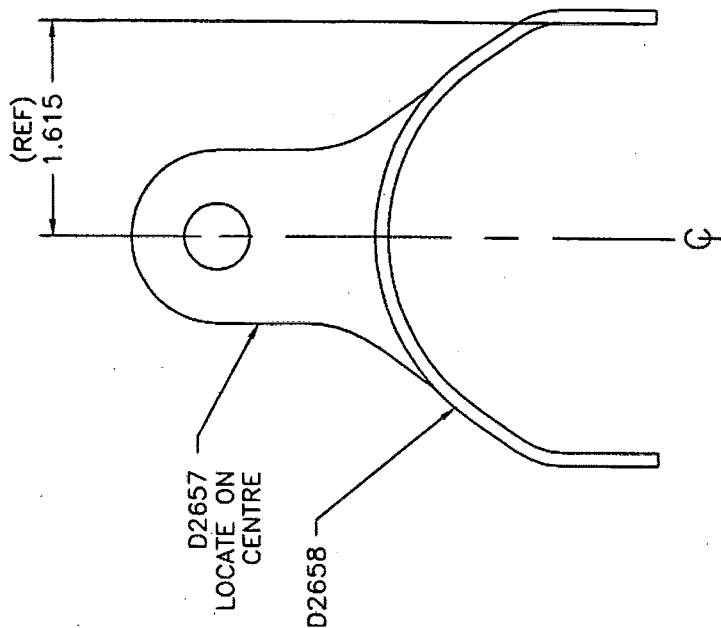
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>DMS</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>S</i>	APPROVED <i>U</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03	TITLE LUG ASSEMBLY		SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13885